

**Work Order ID 74615**

Monday, October 03, 2011 4:05:46 PM



Page 1

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 10/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: M.L.JDate: 11/10/04 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3296	Rev A

100



FLOW WATER JET

Waterjet

Memo 0.00

B11-10-6

FLOW CNC Waterjet

2024.0631-Cut as per Dwg D3296  Dwg Rev: A  Prog Rev: A  2-  
Deburr if necessary1A

110



QC2- Inspect parts off machine FAI/FAIB

QC

Quality Control

0.00

B11-10-6

Memo 0.00

120



QC8- Inspect parts - second check

QC

Quality Control

0.00

S. u. 10-6F. 10-6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup

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Item Name: Door Panel

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Start Date: 10/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

130

Operation  
Description

Small Fab

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Small Fab

Small Fab

Memo  
Deburr

w/456

140



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

16 BR 11-10-7

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

16 d 24 11-10-7

COOLIT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**Work Order ID 74615**

Monday, October 03, 2011 4:05:46 PM



Page 3

Item ID: D3296-3

Accept



Setup Start



Revision ID:

Item Name: Door Panel

Stop



Start Date: 10/3/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 10/5/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

160



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location 160Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170



QC

Quality Control

Memo

0.00

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

160 8/11-10-11

11-10-11 JH

11-10-11

16

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Picklist Print

Monday, October 03, 2011 4:05:51 PM

Page 1

Work Order ID: 74615



Parent Item: D3296-3



Parent Item Name: Door Panel

Start Date: 10/3/2011

Required Date: 10/5/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C 05.10.14 Added step 14 KJ/EC  
IPP Rev:E Now on Waterjet 06-11-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased		No		110	sf	115.5000	0.6532	5.500632	10.5		

2024-T3 .063 sheet

Location	Loc Qty	Loc Code
MAT022	115.5	
117392	115.5	

117392

16

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	74615
Description: Door Panel	Part Number:	D3296-3
Inspection Dwg: D3296 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by: <u>A</u>	Audited by: <u>J</u>	Prototype Approval: N/A
Date: 11-10-6	Date: 11/10/66	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	P/O D3296-041	KJ/JLM 

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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NOTE: Date & initial all entries

SHOP DRAW

RETURN TO

ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 4615

D3161-7 HINGE

.063

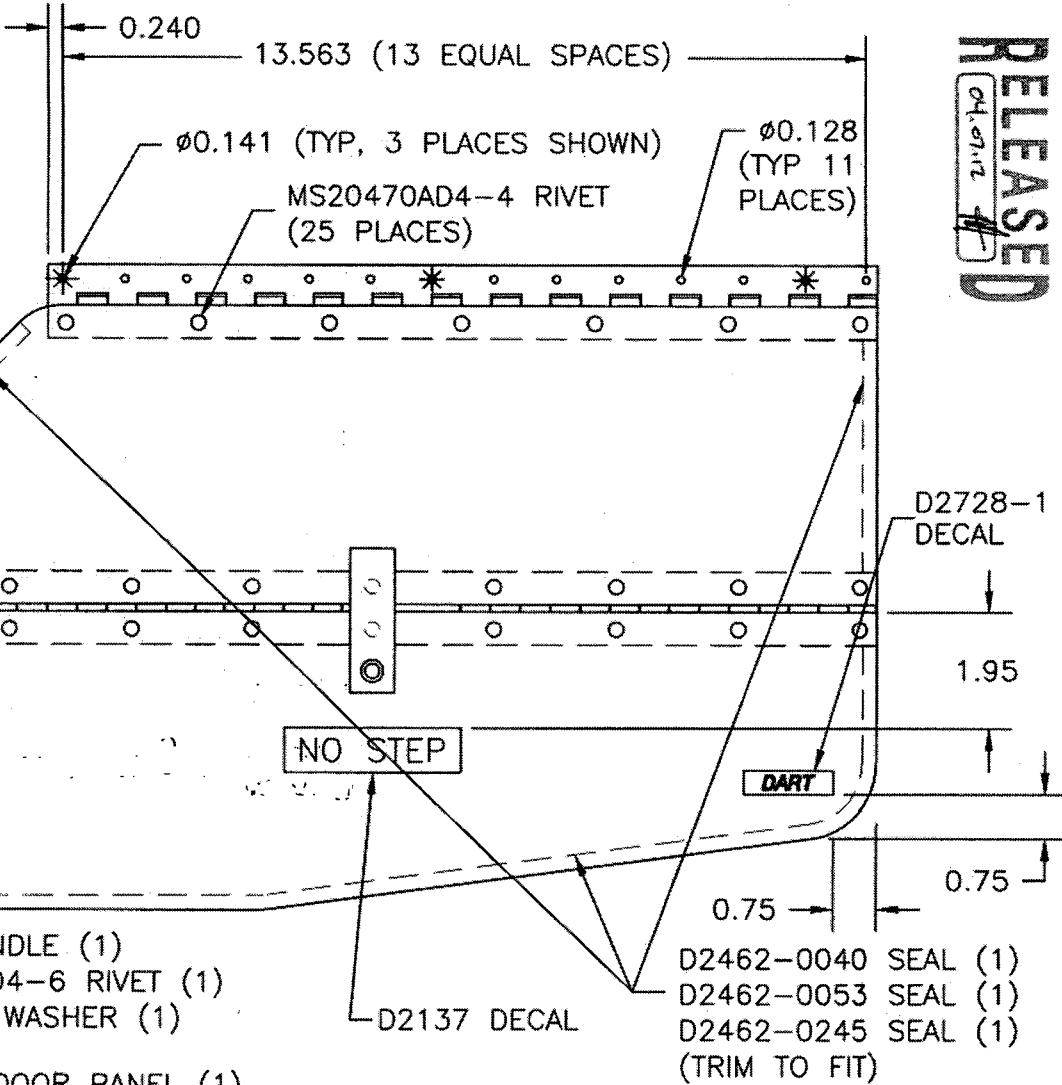
D3296-1 DOOR  
PANEL (1)

D3161-9  
HINGE

0.125

D2419 HANDLE (1)  
MS20470AD4-6 RIVET (1)  
AN960JD6 WASHER (1)

D3296-3 DOOR PANEL (1)



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**DART**

COPY  
04.07.02

DESIGN	DRAWN BY	DART AEROSPACE LTD
4	M	HAWKESBURY, ONTARIO, CANADA
DATE	APPROVED	REV. A 1 OF 2
04.06.28		SCALE 1:3
A	04.06.28	NEW ISSUE
		TITLE DOOR ASSEMBLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

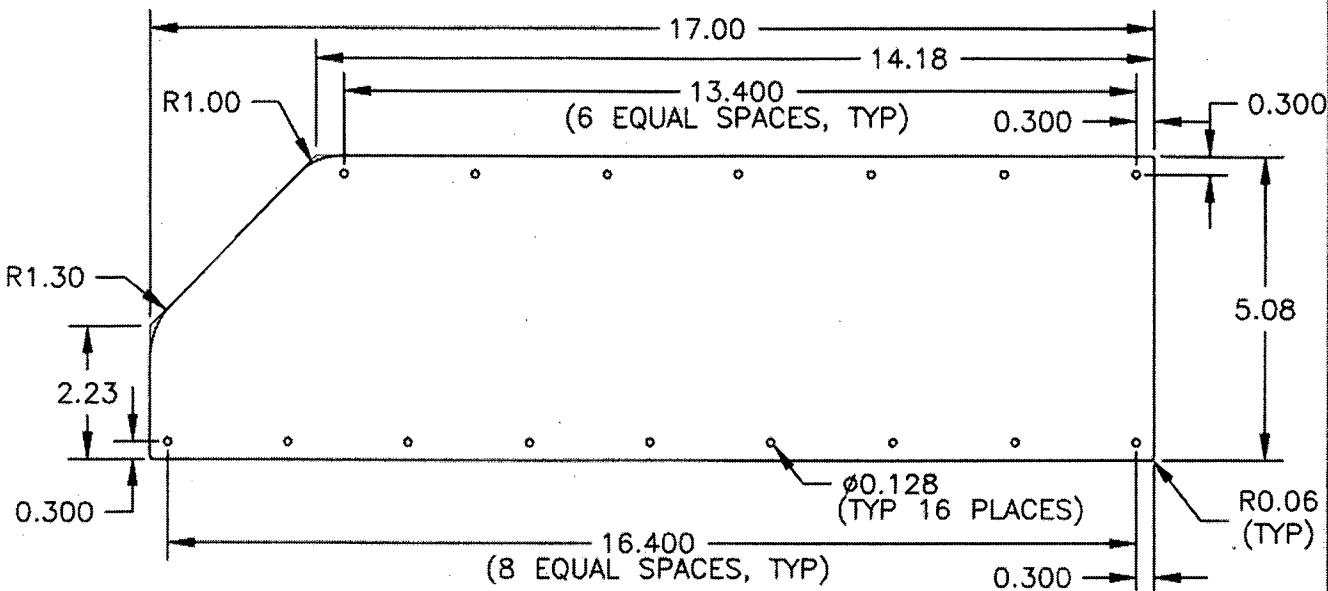
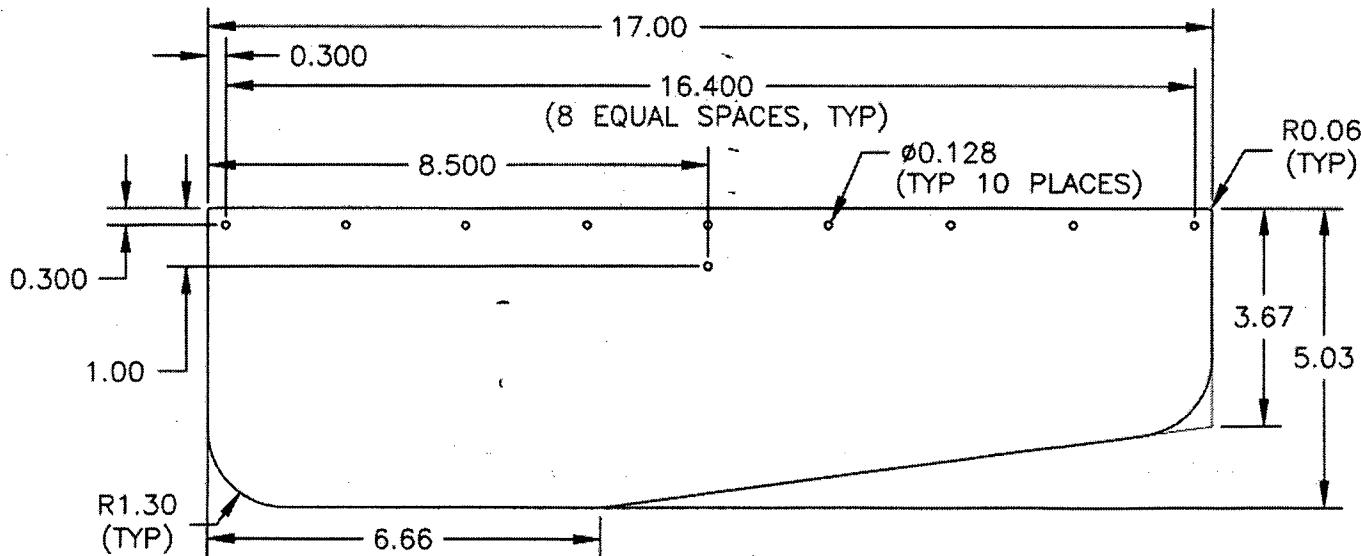
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3296	2 OF 2

DATE  
04.06.28TITLE  
DOOR ASSEMBLYSCALE  
1:3D3296-1 DOOR PANELD3296-3 DOOR PANELD3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK  
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**RELEASED**

04.07.12

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